Work Order ID 80638 *80638*

March-28-12 10:18:00 AM

Item ID: D350-567-141 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Floor Window Closeout Installation

Start Date: 2/24/12 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 3/15/12 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
DSI 9590	B

100		0.00			
100	DOCUMENT CONTROL				
DC	**Memo**	0.00			
Document Control	Photocopy bluefile & type labels per PPP D350-567-141 CHG002		8 12/03/29		
110	Pick Kit	0.00			
110					
Packaging	**Memo**	0.00		JB	12/03/28
Packaging					
120	QC4- 100% Inspect kits for completeness	0.00			
120					
QC	**Memo**	0.00	8 12/03/29	(46)	
Quality Control					

Work Order ID 80638

March-28-12 10:18:00 AM

80638

Item ID:	D350-567-141	**Accept**	*N900040100*
Revision ID:			
Item Name:	Floor Window Closeout Installation		

Setup **Start** *NS1*
Stop *NS2*

Start Date:	2/24/12	**Start Qty:** 6.00	*6*	**Cust Item ID:**
Required Date:	3/15/12	**Req'd Qty:** 6.00	*6*	**Customer:**
Reference:				

Run **Start** *NR1*
Stop *NR2*

Approvals:	**Process Plan:**	**Date:**	**Tooling:**	**Date:**
	QC:	**Date:**	**SPC (Y/N):**	**Date:**

Sequence ID/ Work Center ID	**Operation Description**	**Set Up/ Run Hours**	**Tool ID**	**Tool #**	**Plan Code**	**Accept Qty**	**Reject Qty**	**Reject Number**	**Insp. Stamp**
130 *130* Packaging Packaging	Packaging	0.00							C 12/3/29 (6)
	Memo Identify and pack for shipping as per PPP D350-567-141 Location:_________ SHIP DRAFT	0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							12/3/29
	Memo	0.00							ME 12-03-29

Picklist Print

March-28-12 10:17:59 AM

4

Work Order ID: **80638**

Parent Item: **D350-567-141**

Parent Item Name: Floor Window Closeout Installation

Start Date: 2/24/12 **Required Date:** 3/15/12

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-832R7 Screw (S +6)		Purchased	No				Each	640.0000	2	**12**	✓ JB		✓

Location		Loc Qty	Loc Code	
ST345		640		
	120519	140		
	120560	500		120560

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L08 Nut (S +6)		Purchased	No				Each	410.0000	2	**12**	✓ JB		✓

Location		Loc Qty	Loc Code	
ST300		410		
	120142	19		
	120648	191		120648
	120833	200		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35206-229 Screw (S +6)		Purchased	No				Each	380.0000	7	**42**	✓ JB		✓

Location		Loc Qty	Loc Code	
ST293		380		
	121039	380		121039

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
(S +6) * **NAS1149FN882P** (816P) Washer		Purchased	No				Each	0.0000	2 (121039)	**12**			✓
D3802-1 Window Seal (D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT. (S +6)		Manufactured	No			110	f	557.7500	2	**12**	✓ JB		✓

Location		Loc Qty	Loc Code	
ST412		557.75		
	56881	0.75		
	81021	57		81021
	81868	500		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
(S +6) * **D4434-041** Fwd Bracket Assembly		Manufactured	No			110	Each	0.0000	* 1	**6**			

SU66U 12/03/28

12/3/28

Work Order ID: 80638

Parent Item: D350-567-141 **Start Date:** 2/24/12 **Required Date:** 3/15/12

Parent Item Name: Floor Window Closeout Installation **Start Qty:** 6.00 **Required Qty:** 6.00

D4434-047 Cover Assembly	Manufactured	No	110	Each	0.0000	1	5X80657 6	✓ JB
D4435-045 T/R Bellcrank Cover Assembly	Manufactured	No	110	Each	19.0000	1X 79381	1X 79382 6	✓ JB

Location		Loc Qty	Loc Code	
ST-441		19		
	80650	10		
	80651	9		5X80651

D4435-97 Bracket	Manufactured	No	110	Each	39.0000	2	12	✓ JB

Location		Loc Qty	Loc Code	
ST441		39		
	80659	39		80659

D4436-041 Aft Bracket Assembly	Manufactured	No	110	Each	0.0000	1	80640 6	✓ JB

Location		Loc Qty	Loc Code	
ST		-9		
ST441		9		

D4441-1 Rubber Seal (D4441-1-240) CUT (1) AT 24.00" PER KIT	Manufactured	No	110	f	182.6290	2	12	✓ JB

→ reissued 5/2/13

Location		Loc Qty	Loc Code	
prelim		6.739		
	74760	6.739		
ST413		175.89		
	79385	165.99		79385
	80763	9.9		

AN3-3A Bolt	Purchased	No	110	Each	701.0000	7	42	✓ JB

Location		Loc Qty	Loc Code	
ST350		701		
	120423	701		120423

12/03/28

Work Order ID: 80638

Parent Item: **D350-567-141**

Parent Item Name: Floor Window Closeout Installation

Start Date: 2/24/12 **Required Date:** 3/15/12

Start Qty: 6.00 **Required Qty:** 6.00

MS21042L06 Nut	Purchased	No	110	Each	370.0000	7	**54**	✓ JB

Location	Loc Qty	Loc Code
ST300	370	
118354	2	
119109	1	
119758	1	
120360	366	120360

MS21042L3 Nut	Purchased	No	110	Each	2,666.0000	5	**30**	✓ JB

Location	Loc Qty	Loc Code
ST300	2666	
117441	16	
117885	32	
118451	5	
118927	3	
119017	2344	119017
119075	166	
121162	100	

MS21059L3 Nut Plate	Purchased	No	110	Each	247.0000	2	**12**	✓ JB

Location	Loc Qty	Loc Code
ST301	28	
118614	8	
119546	20	
ST302	219	
120308	19	
120833	100	120833
121011	100	

12/03/28

Work Order ID: 80638

Parent Item: D350-567-141 **Start Date:** 2/24/12 **Required Date:** 3/15/12

Parent Item Name: Floor Window Closeout Installation **Start Qty:** 6.00 **Required Qty:** 6.00

NAS1149F0332P WASHER	Purchased	No	110	Each	782.0000	12	72	✓

Location	Loc Qty	Loc Code
ST275	782	
117735	37	
119225	10	
120498	132	120498
120910	200	
120986	200	
121166	200	
17317	3	

NAS1149FN616P WASHER	Purchased	No	110	Each	1,051.0000	14	54	✓ JB

Location	Loc Qty	Loc Code
ST275	1051	
117317	51	18X 117317
120560	1000	36X 120560

12/03/28

REFERENCE ONLY

2.0 Part List

Qty -141	Part Number	Description
X	**D350-567-141**	**FLOOR WINDOW CLOSE-OUT KIT**
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

C

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

4.0 Installation Procedure

Notes:

1) Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
2) In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
   - D350-567-115 — OK to remove D3295-041
   - D350-567-031 — OK to remove D3212-1
   - D350-567-011 — OK to remove D2214
   - D350-567-021 — OK to remove D2951
3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [signature]
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	[signature]	DRAWING NO. DSI 9590	REV. C SHEET 2 OF 12
MFG. APPR.	N/A		
APPROVED	[signature]	TITLE FLOOR WINDOW CLOSE-OUT KIT	SCALE NTS
DE APPR.	[signature]		
DATE	12.03.13		

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